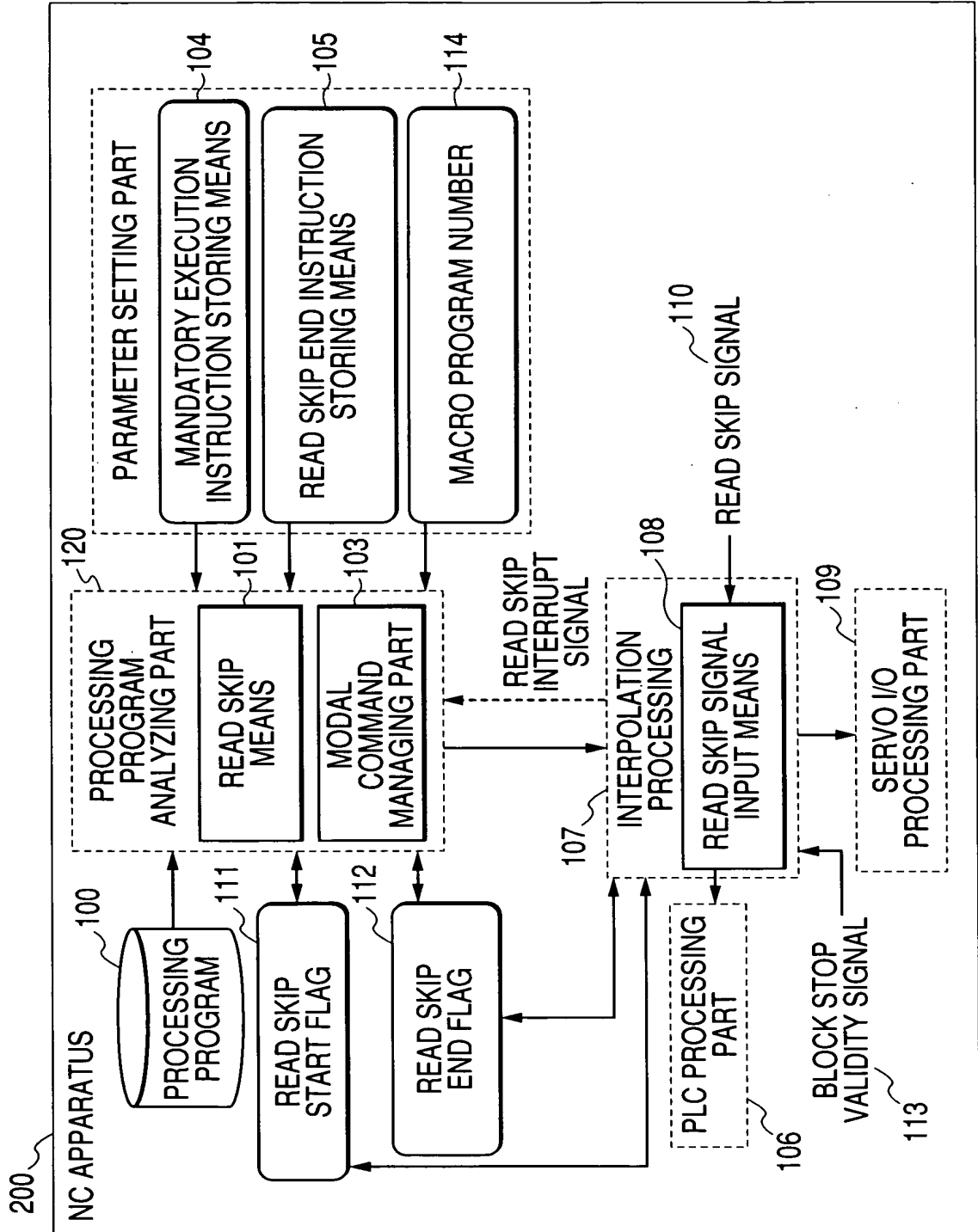


FIG. 1



2 / 7

FIG. 2

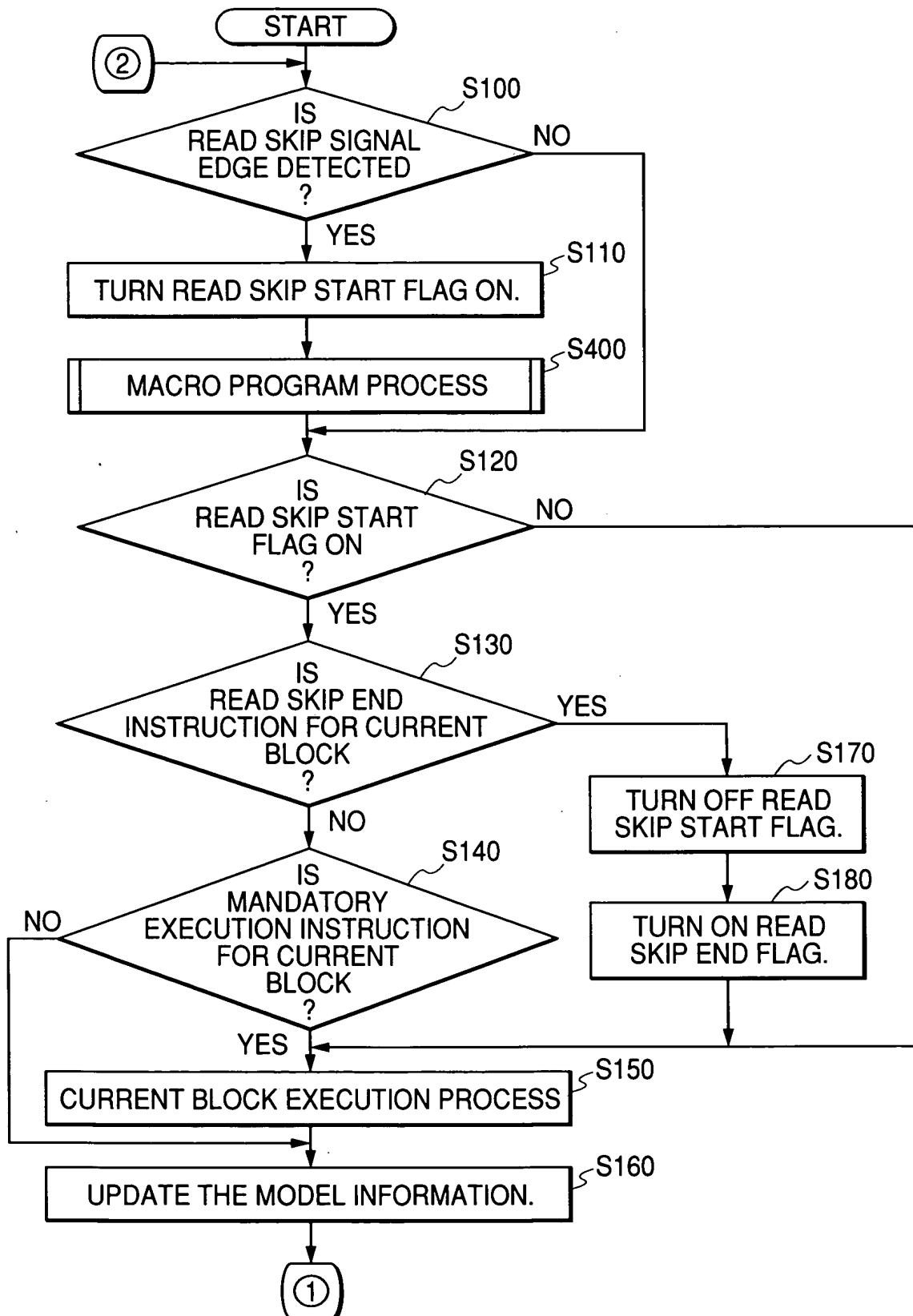
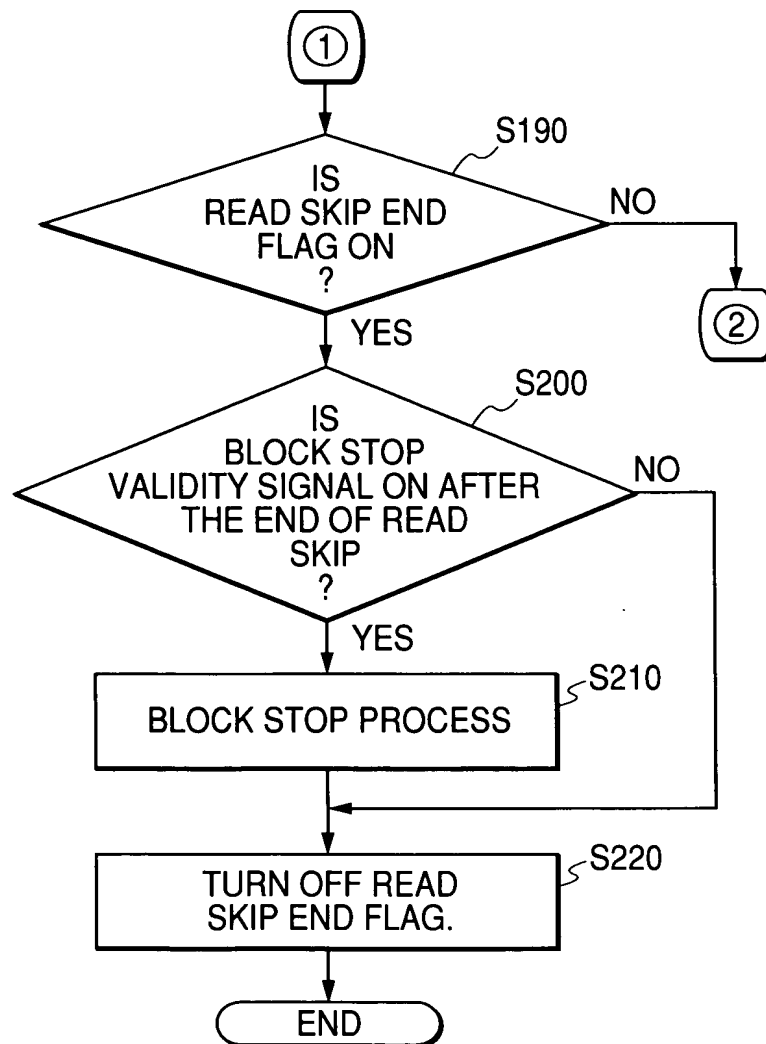
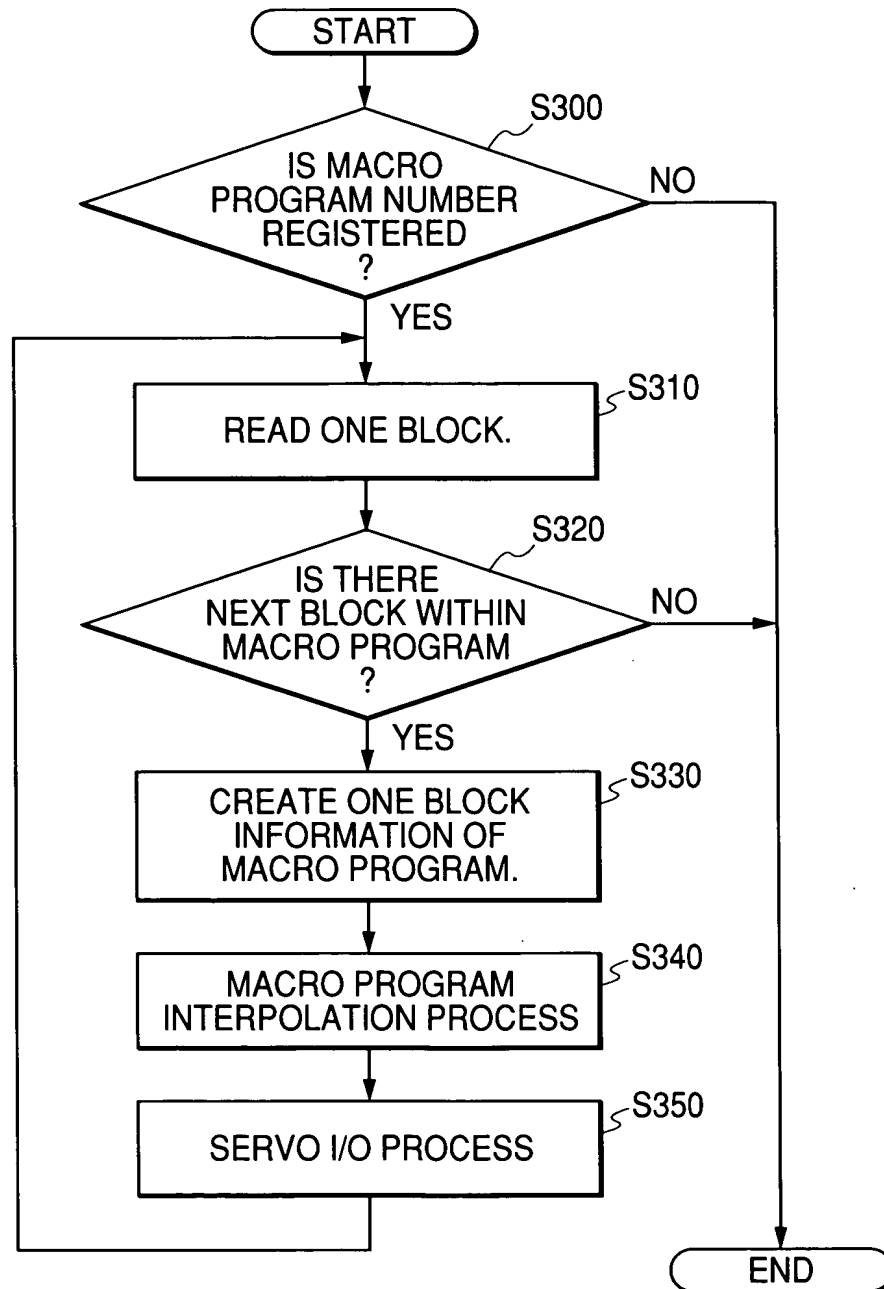


FIG. 3



4 / 7

FIG. 4



10/501866
Rec'd PCT/PTO 20 JUL 2004

5/7

FIG. 5

...

N010 T01 ;
N020 G91 G30 X0 Y0 Z0 ;
N030 M06 ;
N040 G90 X10. Y10.
N050 Z10.;
N060 G01 Z50. F0.2;
...

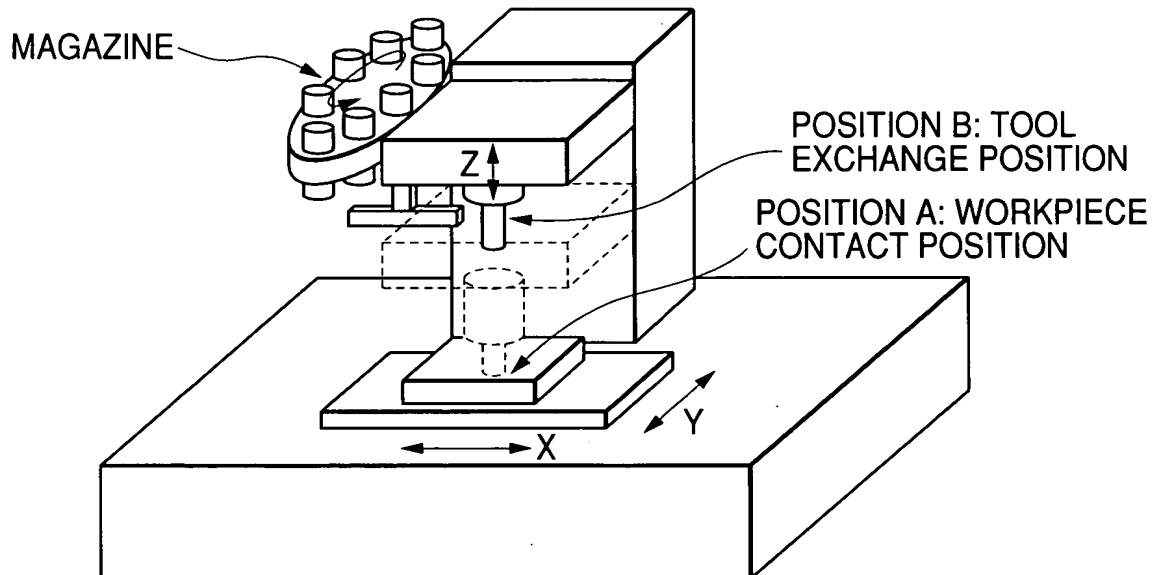
N100 T02 ;
N110 G00 X50. Y50.;
...

N300 G91 G30 X0 Y0 Z0 ;
N310 M06 ;
.....
...

FIG. 6

G28 W0.;
M99;

FIG. 7



10/501866

Rec'd PCT/PTO 20 JUL 2004

7/7

FIG. 8

TOOL NUMBER	LONG SIZE	LONG WEAR	DIAMETER SIZE	DIAMETER WEAR	MACHINE POSITION	RESIDUAL DISTANCE
1	1.120	0.000	1.020	0.000	X 12.090	0.910
2	2.020	0.000	1.900	0.000	Y 15.000	0.000
3	0.000	0.000	0.000	0.000	Z 4.000	1.000
4	4.002	0.020	3.055	0.100	B 10.000	0.000
5	0.000	0.000	0.000	0.000		
6	3.021	0.000	2.003	0.000		
7	0.000	0.000	0.000	0.000		
8	0.000	0.000	0.000	0.000		
9	0.000	0.000	0.000	0.000		
10	0.000	0.000	0.000	0.000		

G00Y15.B10.;

G01X13.Z5.F2000;

...

..

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...